<b>vvork Order</b> August-06-13/11:0		160		*10!	54	ິດ*						Page
Revision ID:	93204-7 ushing			Accept	*	N900	<u>1040</u>	100	)* ፡	Setup Star Sto	171	S1* S2*
Start Date: 8/ Required Date: 8/ Reference:		Start Qty: 40.00 Req'd Qty: 40.00	<del></del>			Cust Item Customer:	ID:					
	Process Plan:	Wrz	Date: \3.08-0	Coling:	<sub>1</sub>	, D	ate:	_	I	Run Star	1/7	R1*
(	GC:	<del>-</del>	Date:	SPC (Y/N):	-	<u> </u> D	ate:			Sto	ໍ *N	R2*
Sequence ID/ Work Center ID		peration escription	<del>-</del>	Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D3204	Rev Al	<u> </u>										
100 *400*	H	ardinge CNC LATHE	SMALL.	0.00	 24-					· -		
*100* Hardinge		Memo		0.00	000	· 13/0	PO/81		40	\$		_ <del></del>
Hardinge CNC Lathe St	mall		204-7 bushing as per Folio F		2-Deburt							
110	Qe	C2- Inspect parts off r	nachine FAI/FAIB	0.00	, 5 !							
*110* QC Quality Control		Мето		0.00	000	13/0	<sub>38</sub> /09		-46-	<u> </u>	. <u></u>	<del>-</del> — <del>-</del> —
-					1							
120	QC	C8- Inspect parts - sec	ond check	0.00	27%	( 13/0	8/09					
*120* <sup>QC</sup>		Memo		0.00			<b>- ,</b>		40	_6		
Quality Control					- 1							

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	VFORM	MANCE / UPDATE				
											QA Closed:	Date:	
Work Ord	or.				,	DISPOSITION			AG	AINST DE	PARTMENT	/PROCESS	
WOIK OIG	ет.	<del></del>	_			Rework	٦		Skid-tube Cros	sstube	1	Water Jet	Engineering
Part	No.					Scrap	┥ !		·	all Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		<b>→</b>	ishing		re/Packaging	Other
NCR	No.					Work Order Update	1		Large Fab Com	posite	]	Supplier	
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Root					'	ption of work order update		initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	ief Eng	Description		Date	Verification	QC Inspector
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Equip/Tooling	$\square$			1									
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Land	ing (	Goar				General	AUI	CAIL	<u> </u>				<del></del>
Lanu	<u> </u>	Bending				Bend	Г	Grain			Ovalized		Pressure/Forced
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	$\vdash$	Cuffs			<u> </u>	Contamination	<b> </b>	Mainte	•		Part Moved	_	_
		Heat Tre	at		<u> </u>	Countersink		Mislabe	led		Positioned V	<b>V</b> rong	
		Inspectio		Tube		Cut Too Short	Г	Misread	1	_	Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord August-06-13				*10:	54၉Ո*
Item ID: Revision ID:	D3204-7			Accept	*N90
Item Name: Start Date: Required Date Reference:	Bushing 8/06/13 : 8/20/13	Start Qty: 40.00 Req'd Qty: 40.00	-	በ* በ*	Cust Ite Custom
Approvals:	Process F	Plan:	Date:	Tooling: SPC (Y/N):	
Sequence ID/ Work Center I 130 *120* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ock Location:	•	Tool
¹ <sup>40</sup> *1 <b>∡∩</b> *		QC21- Final Inspection -	Work Order Releas	se 0.00	
QC Quality Control		Мето		0.00	

190	<u> </u>	100	)* s	etup	Star	*N	S1*
Cust Iten	n ID;				Stop	*N	S2*
Custome	r:						
	Date:	- 	R	un	Start	171	R1*
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Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
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MC 13-08-13. MF 13-8-12

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:									QA Closed:	Date	
·				DISPOSITION			AGA	INST DE	PARTMENT,	/PROCESS	
Part No.  NCR No.			<del></del>	Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Work Order Update Large Fab Composite			ll Fab	4	_	Engineering Quality Other	
				,							
Date	Step	Qty		·			Action Description		Sign & Date	Verification	QC Inspector
							•,				
					FAUI	LT CATE	GORY		<u> </u>		
Bending Centre I Cracks Crushed Cuffs Heat Tre Inspecti Ripples	lot Conce /Crimped eat on Strip in	Tube	/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspecti Instruct Mainte Mislabe Misread Offset	on Incomplete ons Incomplete/Unclear nance led		Part Incorred Part Lost/Mi Part Moved Positioned V	ct sssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Date  Date  Gear  Bending  Centre N  Cracks  Crushed  Cuffs  Heat Tre  Inspectic	Date Step  Date Step  Gear  Bending Centre Not Conce Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend	Date Step Qty  Gear  Bending  Centre Not Concentric to O/ Cracks  Crushed/Crimped  Cuffs  Heat Treat Inspection Strip in Tube	Date Step Qty  Gear  Bending  Centre Not Concentric to O/S  Cracks  Crushed/Crimped  Cuffs  Heat Treat  Inspection Strip in Tube  Ripples in Bend	Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  General Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Rework Scrap Use-as-is Work Order Update or Non-conformance  General Bend BoM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	Rework Scrap Use-as-is Work Order Update  Date Step Qty  Description of work order update or Non-conformance  General Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Cut Too Short Ripples in Bend Cisc Scrap Use-as-is Work Order Update Or Non-conformance  FAU Scrap Use-as-is Work Order Update Or Non-conformance  FAU Scrap Use-as-is Work Order Update Or Non-conformance  FAU Scrap Use-as-is Work Order Update Or Non-conformance  Cut Seneral Bend Contamination Countersink Countersink Cut Too Short Drill Holes	Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance Chief Eng  FAULT CATE  Gear General  Bending Bend Grain  Centre Not Concentric to O/S BOM/Route Hardwar  Cracks Broken/Damaged Inspection  Cracks Grain Hardwar  Cracks Crushed/Crimped Burrs Inspection  Cuffs Contamination Mainte  Heat Treat Countersink Mislabe  Inspection Strip in Tube Cut Too Short Misread  Ripples in Bend Drill Holes Offset	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Unitial Comp    Date   Step   Qty   Description of work order update or Non-conformance   Chief Eng   Description	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Use-as-is Work Order Update Use-as-is U	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is	Rework Scrap Use-as-is Use-as-is Work Order Update Use-as-is Use-as-is-as-is-as-is-as-is-as-is-as-is-as-is-as-is-as-is-as-is-a

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

CERUSE Print

iugusi-06-13 11:04:11 AM

Work Order ID: 105460

Parent Item: D3204-7

Parent Item Name: Bushing

\*105460\* \*D3204-7\*

Comments:

IPP: B04.06.09Change Step 6; remove Steps 7 & 8KJ/RF

Component Item ID/ Replacement Mfg/ Bin Primary Last Item Name Item ID Purch Item Location

M303R0.500 Purchased No

\*M303R0 500\*

303 Round Bar 0.500"

 Location
 Loc Oty
 Loc

 MAT028
 40.74330000
 1E-09

 124711
 22.2
 125387

 ★ M126153
 17.64

Route

Seq ID

Unit of

Measure

Qty on

Hand

Start Date: 8/06/13

Required Date: 8/20/13

Start Qty: 40.00

Qty per Kit

Total

**Qty** 

Qty

Issued

Required Qty: 40.00

Date

Issued

Status

100 f 40.7433 0.0358 1.507368

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Loc Oty
40.74330000
1E-09
22.2
0.9033
17.64

Loc Code

1.507368

										DQA.	Date.	
NCR: Ye	s / No				WORK ORDER NON-	O	NFORM	MANCE / UPDATE		QA Closed:	 Date:	
Mark Ordon					DISPOSITION			AGA	AINST DE	PARTMENT,	/PROCESS	
Work Order: Part No NCR No	). 				Rework Scrap Use-as-is Work Order Update		Thern	Machining Sma	stube II Fab shing oosite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		T		Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Cr	ief Eng	Description		Date	Verification	QC Inspector
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Material	]										•	
Setup												
Other		1										
Process						ŀ						
Supplier		4	]									:
Training												
Unapproved												
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Landing	Gear				General					_		_
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	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct	Weld
	Crushed	/Crimped	_		Rurrs		l <sub>instruct</sub>	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	105460
Description: Bushing	Part Number:	D3204-7
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	F000	7		FK-04	Vern.
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Ø0.500	+/-0.005	.500	)		15	h
Ø0.376	+0.001/-0.000	-3766	7		FK-09.	Mic
Ø0.257	+0.005/-0.000	-257	7	,	FK-04	Yern.
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Measured by:		Audited by:	and	Prototype Approval:	N/A
Date:	13/08/09.	Date:	13/68/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM	1
В	06.03.21	Dwg Rev update	KJ/JLM 🚓	

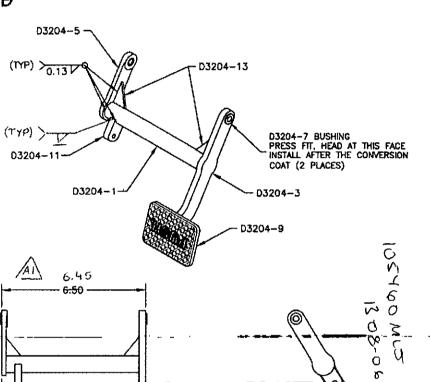
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	DATE	<del>-</del>		TITLE	SCALE			
	04.01.	27		RELEASE PEDAL ASSEMBLY	NTS			
	Α	il	04.01.27	NEW ISSUE				
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## D3204-041 RELEASE PEDAL ASSEMBLY

## NOTES

0.600

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
  6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
  ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
  7) WELD ASSEMBLY PER QSI 004

- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
  10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

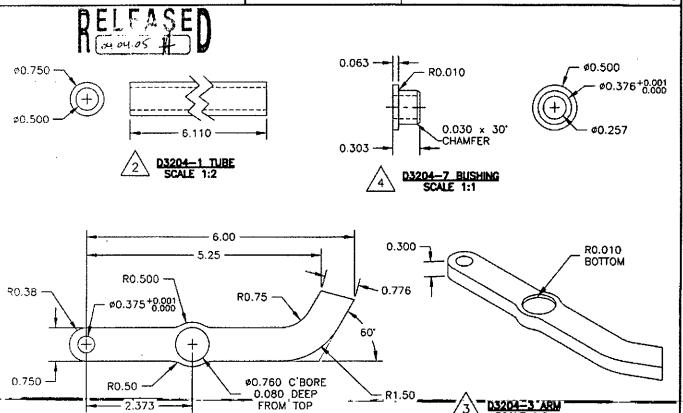
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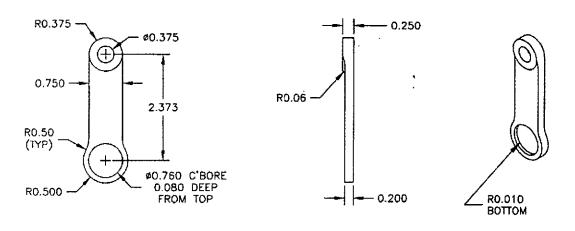


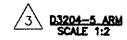


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04.01.27		RELEASE PEDAL ASSEMBLY	NTS

SCALE 1:2







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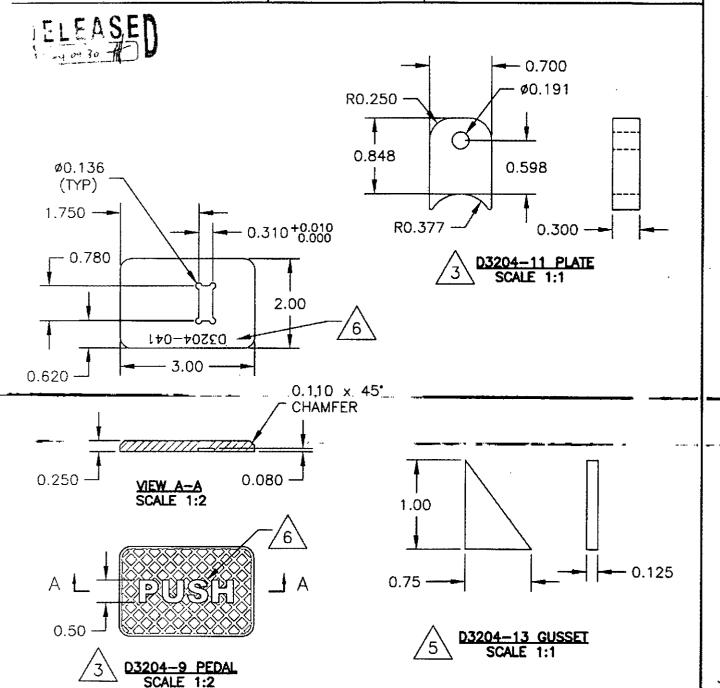
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